

012566



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7501

Job Sheet 201889



Part No: 647.7501

Job Qty: 2 pcs

Part Name: Lower Cutter Assembly



Part Weight: 0 lbs

Job Created: 10/16/19

Due Date: 11/18/19

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV A IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Packaging 1 - Pick Kit	2 pcs		11/18/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

DAS

41

OCT 29 2019

9:59



Container No: S227570



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaero.com

Part: 647.7501

Job No: 201889

Serial No/Batch: S227570

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/29/19

					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120 Small Fab - 2 - B4B	2 pcs	11/18/19	0.00 2.56	Small Fab - 1 - B4B		
				Small Fab - 2 - B4B		
				Small Fab - 3 - B4B		
				Small Fab - 4 - B4B		
				Small Fab - 5 - B4B	DAS	
				Small Fab - 6 - B4B	41	OCT 29 2019
				Small Fab - 7 - B4B	3-89	
				Small Fab - 8 - B4B		
130 QC 5	2 pcs	11/18/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58	DAS	
				QC 5 - 68	NOV 18 2019	68
				QC 5 - 9		9-89
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
140 Packaging 3-1 - Stock - B4B	2 pcs	11/18/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B	DAS	
				Packaging 3 - 4 - B4B	74	
				Packaging 3 - 5 - B4B	9-89	
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		

				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	2 pcs	11/18/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	NOV 21 2019

Part Op 120 - Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2. S211075 exp 1/21
 Descriptions: 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Identify as per dwg & Stock Location: _____), ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3015	Blade CCK102	4 pcs (2 ea)	110-Packaging 1 - Pick Kit	S105905.
647.7601	Lower Deflector Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S225456
647.7810	Bracket A CCK077A	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S115101
647.7811	Bracket B CCK077A	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S114688
647.7813	Center Plate, Lower CCK122A	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S107160
647.7814	Fwd Bracket CCK114	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S107160 183836
647.7815	Fwd Bracket CCK122A	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S113568
647.7816	Aft Bracket CCK122A	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S113471
647.7817	Aft Bracket CCK115	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S118838
MS21042L08	Nut ST303	26 Ea (13 ea)	110-Packaging 1 - Pick Kit	S205000
MS21042L3	Nut ST303	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	S211532
MS27039-08-19	Screw GA015	14 Ea (7 ea)	110-Packaging 1 - Pick Kit	S204996
MS27039-08-24	Screw (MS27039-0824) ST277	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	S192376
MS27039-1-19	Screw ST280	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	S216386
NAS1149F0332P	Washer (AN960-10L) ST262	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	S207709
NAS1149FN832P	Washer (AN960-8) ST263	52 Ea (26 ea)	110-Packaging 1 - Pick Kit	S207676

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3015	4	5	0
	647.7601	2	0	0
	647.7810	2	29	0
	647.7811	2	31	0
	647.7813	2	36	0
	647.7814	2	11	0
	647.7815	2	37	0
	647.7816	2	36	0
	647.7817	2	35	0
	MS21042L08	26	995	0
	MS21042L3	6	2,849	0
	MS27039-08-19	14	622	0
	MS27039-08-24	12	89	0
	MS27039-1-19	6	381	0
	NAS1149F0332P	12	2,634	0
	NAS1149FN832P	52	1,617	0

Part Specifications

Specifications could not be found.



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____

Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐